

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003083**Date Inspected:** 09-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sai Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck Panels**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance (QA) Inspector Edward Leach was present to randomly observe and document the welding and Quality Control (QC) functions performed by ZPMC personnel relative to the fabrication of SAS Superstructure project. While on site, the QA Inspector noted the following work.

Bay 3--New Tower Building

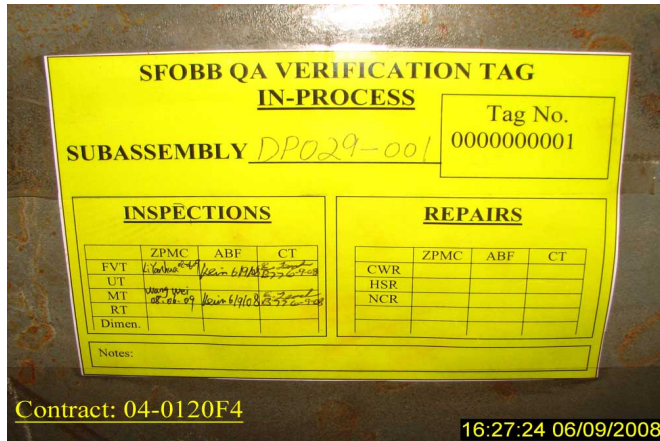
The QA Inspector randomly observed ZPMC welding and QC personnel performing inspection, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that thirty-one (35ea) deck panels are inside the shop. The deck panels in repair process are designated as: DP055-001 & DP065-001.

Visual Testing (VT) / Magnetic Particle Testing (MT)

The QA Inspector performed final VT and MT along with ABF and ZPMC QC personnel on completed deck panel repairs for DP029-001. Once the inspection was completed and a mutual agreement was reached towards compliance of repaired areas, a representative from the three parties signed the in-process repair tag indicating that inspections were completed. The QA Inspector generated a TL-6028 MT report on this date.

WELDING INSPECTION REPORT

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A yellow verification tag with the title "SFOBB QA VERIFICATION TAG IN-PROCESS". It includes a "Tag No." field with the value "0000000001" and a "SUBASSEMBLY" field with the handwritten value "DP029-001". Below these are two tables: "INSPECTIONS" and "REPAIRS". The "INSPECTIONS" table has columns for ZPMC, ABE, and CT, with rows for FVT, UT, MT, RT, and Dimen. The "REPAIRS" table has columns for ZPMC, ABE, and CT, with rows for CWR, HSR, and NCR. A "Notes:" field is at the bottom. The tag is stamped with "Contract: 04-0120F4" and a timestamp "16:27:24 06/09/2008".

SFOBB QA VERIFICATION TAG IN-PROCESS			
SUBASSEMBLY <u>DP029-001</u>			Tag No. 0000000001
INSPECTIONS			
FVT	ZPMC	ABE	CT
UT			
MT			
RT			
Dimen.			
Notes:			
Contract: 04-0120F4			
16:27:24 06/09/2008			



Summary of Conversations:

No relevant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Leach,Ed

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer